

Work Order ID 62579

Monday, October 04, 2010 2:29:47 PM



Page 1

Item ID: D412-742-013

Accept



Setup Start



Revision ID:

Stop



Item Name: Float Skidtube Installation

Start Date: 10/4/2010

Start Qty: 1.00



Cust Item ID:

Required Date: 10/15/2010

Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date:

10/04/10

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

IIN D412-742

D

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D412-742-013 CHG006

8/16/12g

CK Per BG 11/04/27

110

0.00



Pick Kit

Packaging

Memo

0.00

Packaging

11/4/27sf

120

0.00



QC4- 100% Inspect kits for completeness

QC

Memo

0.00

Quality Control

8/16/12g

(H)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Stop



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Start Date: 10/4/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 10/15/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

0.00



Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D412-742-013

Location:

Reo H

11/4/29 SP

140

0.00



QC

QC21- Final Inspection - Work Order Release

Memo

0.00

Quality Control

OK 11/04/29

MF

11-04-29

W/O:		WORK ORDER CHANGES					
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... ..

**Required Date:** 10/15/2010

Required Qty: 1.00

Comments: IPP Rev: A 05.10.13 New Issue KJ/JLM
 IPP Rev:B 06-06-08 As per DS19336 JLM IPP RevC 07-12-03 ECN
 1072 DD verified by:JLM
 IPP Rev:D 08-09-08 ecn 08-510 DD verified by:EC
 IPP Rev:E 09-01-23 as per DS19441 DD verified by:EC IPP RevF: add
 AN4C7A DD 10.01.13 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN4C7A 		Purchased	No			110	Each	452.0000	4	4		11/4/27	
Bolt													
				<u>Location</u>									
				ST356				452					
					109147			452					
D412-742-043 } 		Manufactured	No			110	Each	0.0000	1	1		68643 SL 11/4/29	
Replacement Float Skidtube													
D2571 		Manufactured	No			110	Each	22.0000	1	1		B63499 11/4/27	
Saddle, Fwd Out 205													
				<u>Location</u>									
				ST425				7					
					43564			3					
					47564			4					
				ST433				15					
					58250			3					
					61332			12					

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Work Order ID: 62579

Parent Item: D412-742-013

Parent Item Name: Float Skidtube Installation

Start Date: 10/4/2010

Required Date: 10/15/2010

Start Qty: 1.00

Required Qty: 1.00

D2572

Manufactured No

110 Each

9.0000



1 1
B63500

Saddle, Fwd In 205

Location

Loc Qty

Loc Code

ST425

3

43565

3

ST433

6

60705

6

D2573

Manufactured No

110 Each

14.0000



1 1
B63501

Saddle, Aft Out 205

Location

Loc Qty

Loc Code

ST425

7

43566

3

47566

4

ST434

7

60706

7

D2574

Manufactured No

110 Each

10.0000



1 1
B63502 114270

Saddle, Aft In 205

Location

Loc Qty

Loc Code

ST425

3

43567

3

ST434

7

60707

7

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W/O:		WORK ORDER CHANGES					
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Parent Item: D412-742-013



Parent Item Name: Float Skidtube Installation

Start Date: 10/4/2010

Required Date: 10/15/2010

Start Qty: 1.00

Required Qty: 1.00

D2876

Manufactured No

110 Each

62.0000

2

2



Saddle Spacer



B668198

Location

Loc Qty

Loc Code

ST026

49

60853

49

ST028

13

51540

13

D2877

Manufactured No

110 Each

73.0000

2



Saddle Spacer



B63325

Location

Loc Qty

Loc Code

ST026

65

60854

24

61211

41

ST028

8

58531

8

D3403-1

Manufactured No

110 Each

43.0000

16

16



Bushing



B63316 sl 11/4/17

Location

Loc Qty

Loc Code

ST052

30

61654

30

ST055

13

59119

13

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 62579

Parent Item: D412-742-013

Parent Item Name: Float Skidtube Installation

Start Date: 10/4/2010

Required Date: 10/15/2010

Start Qty: 1.00

Required Qty: 1.00

D2747

Manufactured No

110

Each

161.0000

4

4



Set Screw

Location

Loc Qty

Loc Code

ST023

161

39224

4

59879

57

62085

100

Manufactured No

110

Each

47.0000

2

2

D3533-1



Set Screw

Location

Loc Qty

Loc Code

ST069

47

51602

47

Purchased No

110

Each

319.0000

16

16

AN4C6A



Bolt

Location

Loc Qty

Loc Code

FG

4

103344

4

ST

4

103344

0

111295

4

ST356

311

113121

111

115016

200

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 62579

Parent Item: D412-742-013

Parent Item Name: Float Skidtube Installation

Start Date: 10/4/2010

Required Date: 10/15/2010

Start Qty: 1.00

Required Qty: 1.00

AN4C52A

Purchased

No

110

Each

120.0000

8

8



BOLT

Location

Loc Qty

Loc Code

ST361

120

112641

50

113121

20

114784

50

AN6C12A

Purchased

No

110

Each

48.0000

8



BOLT

Location

Loc Qty

Loc Code

ST342

48

114442

48

D3672-3

Manufactured

No

110

Each

542.0000

32

32



Phenolic Washer

Location

Loc Qty

Loc Code

ST077

542

47023

16

57704

526

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 62579

Parent Item: D412-742-013

Parent Item Name: Float Skidtube Installation

Start Date: 10/4/2010

Required Date: 10/15/2010

Start Qty: 1.00

Required Qty: 1.00

AN960C416L

Purchased

No

110

Each

276.0000

32

32

MAS/1400432A
M116900



WASHER

Location

Loc Qty

Loc Code

FG

44

104925

44

ST346

232

106785

10

107008

10

111359

16

112828

155

69220

41

D3672-9

Manufactured

No

110

Each

390.0000

8



Phenolic Washer

Location

Loc Qty

Loc Code

ST077

390

35523

390

AN960C616L

Purchased

No

110

Each

156.0000

8



WASHER

Location

Loc Qty

Loc Code

ST347

156

113064

156

D3672-11

Manufactured

No

110

Each

856.0000

16



Phenolic Washer

Location

Loc Qty

Loc Code

ST077

856

58046

856

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W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 62579

Parent Item: D412-742-013

Parent Item Name: Float Skidtube Installation

Start Date: 10/4/2010

Required Date: 10/15/2010

Start Qty: 1.00

Required Qty: 1.00

MS21043-4

Purchased

No

110

Each

813.0000

29

29

Nut

Location

Loc Qty

Loc Code

FG

40

104603

40

ST301

773

112492

25

113069

8

114523

440

114784

300

D3403-3

Manufactured

No

110

Each

27.0000

8

Bushing

Location

Loc Qty

Loc Code

ST053

25

59598

25

ST055

2

56857

2

D3405-041

Manufactured

No

110

Each

12.0000

1

1

Lug Assembly

Location

Loc Qty

Loc Code

ST474

12

60495

12

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 62579

Parent Item: D412-742-013

Parent Item Name: Float Skidtube Installation

Start Date: 10/4/2010

Required Date: 10/15/2010

Start Qty: 1.00

Required Qty: 1.00

D3405-043

Manufactured No

110

Each

2.0000

1

1



Lug Assembly

Location

Loc Qty

Loc Code

ST474

2

53888

1

56514

1

AN4C47A

Purchased No

110

Each

91.0000

4

4



Bolt

Location

Loc Qty

Loc Code

ST361

91

115231

7

115358

24

115518

40

115836

20

D3407-041

Manufactured No

110

Each

6.0000

1

1



Tow Ring

Location

Loc Qty

Loc Code

ST464

6

59632

6

D3417-3

Manufactured No

110

Each

108.0000

2

2



Washer

Location

Loc Qty

Loc Code

ST056

108

44349

27

51648

28

53182

53

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W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 62579

Parent Item: D412-742-013

Parent Item Name: Float Skidtube Installation

Start Date: 10/4/2010

Required Date: 10/15/2010

Start Qty: 1.00

Required Qty: 1.00

D3456-1



Washer

Manufactured No

110 Each

21.0000

1

1



B68748 SP

Location

Loc Qty

Loc Code

ST058

21

54692

21

Purchased No

110 Each

63.0000

1

1



M117343 SP

AN3C37A



BOLT

Location

Loc Qty

Loc Code

ST354

63

111775

1

114761

12

114801

50

Purchased No

110 Each

112.0000

1

1



11/4/27 SP

AN3C40A



BOLT

Location

Loc Qty

Loc Code

ST354

112

106176

12

112454

50

114442

50

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Work Order ID: 62579

Parent Item: D412-742-013

Parent Item Name: Float Skidtube Installation

Start Date: 10/4/2010

Required Date: 10/15/2010

Start Qty: 1.00

Required Qty: 1.00

AN3C41A

Purchased

No

110

Each

110.0000

1

1



BOLT



1116381 SP

Location

Loc Qty

Loc Code

FG

4

103324

4

ST354

106

108084

7

108409

8

114443

59

115316

32

AN3C42A

Purchased

No

110

Each

107.0000

1

1



BOLT



SP

Location

Loc Qty

Loc Code

ST354

107

106169

7

106176

100

AN3C43A

Purchased

No

110

Each

109.0000

4

4



BOLT



11427 SP

Location

Loc Qty

Loc Code

ST354

109

114330

9

114433

50

114455

50

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 62579

Parent Item: D412-742-013

Parent Item Name: Float Skidtube Installation

Start Date: 10/4/2010

Required Date: 10/15/2010

Start Qty: 1.00

Required Qty: 1.00

AN3C46A

Purchased

No

110

Each

71.0000

5

5



BOLT

Location

Loc Qty

Loc Code

ST355

71

113302

36

115030

15

115518

20

AN960C10L

NAS1149C0332
R

Purchased

No

110

Each

29.0000

26

26



washer

Location

Loc Qty

Loc Code

ST245

29

107534

29

MS21043-3

Purchased

No

110

Each

2,599.000

13

13



Nut

Location

Loc Qty

Loc Code

FG

76

103691

76

ST301

2523

111383

46

112314

2477

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

5.2 D412-742-013 (APICAL TRI-BAG) Float Skidtube Installation Parts List

Item	Qty -013	Qty -043	Part Number	Description
	X		D412-742-013	FLOAT SKIDTUBE INSTALLATION
	1	X	D412-742-043	FLOAT SKIDTUBE
		1	D3391-043	412 FLOAT SKIDTUBE
1		*24	*AN3C4A	*BOLT
3		*12	*AN3C6A	*BOLT
4		*8	*AN3C7A	*BOLT
5		*44	*AN960C10L	*WASHER
21A		*1	*D3564-1	*WEARSHOE (REPLACES D3460-1)
21B		*1	*D3566-1	*GASKET
22A		*1	*D3564-3	*WEARSHOE (REPLACES D3460-3)
22B		*1	*D3566-1	*GASKET
23A		*1	*D3564-5	*WEARSHOE (REPLACES D2577-5)
23B		*1	*D3566-5	*GASKET
10		*1	*D3391-021	*412 FORWARD TUBE
11		**1	**D3401-041	**TOW CAP
12A		**10	**AELS-1032-225	**INSERT (REPLACES NAS1330S3KB166)
12B		**2	**AELS-1032-130	**INSERT (REPLACES NAS1330S3KB166)
13		**10	**AN3C4A	**BOLT
14A		**4	**D3672-1	**WASHER (REPLACES NAS1515H3L)
14B		**10	**AN960C10L	**WASHER
24A		**1	**D3564-13	**WEARSHOE
24B		**1	**D3566-13	**GASKET
20		*1	*D3391-023	*412 MID TUBE
28		**20	**AELS-1032-130	**INSERT (REPLACES NAS1330S3KB116)
30		*1	*D3391-025	*412 AFT TUBE
25A		**1	*D3537-1	**WEARPAD
25B		**1	*D3553-1	**GASKET
26A		**1	*D3537-7	**WEARPAD
26B		**1	*D3553-3	**GASKET
31		**1	**D2646	**AFT CAP
32		**14	**AELS-1032-130	**INSERT
36		**12	**AELS-1032-225	**INSERT (REPLACES NAS1330S3KB366)
37A		**6	**AN3C4A	**BOLT
37B		**4	**AN3C5A	**BOLT
38A		**2	**D3672-1	**WASHER (REPLACES NAS1515H3L)
38B		**10	**AN960C10L	**WASHER

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Item	Qty -013	Qty -043	Part Number	Description
40	1		D2571	SADDLE, FWD OUTSIDE
41	1		D2572	SADDLE, FWD INSIDE
42	1		D2573	SADDLE, AFT OUTSIDE
43	1		D2574	SADDLE, AFT INSIDE
44	2		D2876	SADDLE SPACER
45	2		D2877	SADDLE SPACER
46	16		D3403-1	BUSHING
47A	4		D2747	SET SCREW
47B	2		D3533-1	SET SCREW
48	16		AN4C6A	BOLT
49	8		AN4C52A	BOLT
50	8		AN6C12A	BOLT
51A	32		D3672-3	WASHER (REPLACES NAS1515H4L)
51B	32		AN960C416L	WASHER
52A	8		D3672-9	WASHER (REPLACES NAS1515H6L)
52B	8		AN960C616L	WASHER
53	16		D3672-11	WASHER (REPLACES NAS1515H7L)
54	24		MS21043-4	NUT
55	4		ANC47A	BOLT
60	8		D3403-3	BUSHING
61	1		D3405-041	GHW LUG
62	1		D3405-043	GHW LUG
63	4		AN4C46A	BOLT
64	4		MS21043-4	NUT
70	1		D3407-041	TOW RING
71	2		D3417-3	WASHER
72	1		MS21043-4	NUT
73	1		D3456-1	WASHER
91	1		AN3C37A	BOLT
92	1		AN3C40A	BOLT
93	1		AN3C41A	BOLT
94	1		AN3C42A	BOLT
95	4		AN3C43A	BOLT
97	5		AN3C46A	BOLT
99	26		AN960C10L	WASHER
100	13		MS21043-3	NUT

*DENOTES PART IS INCLUDED WITH D3391-043 ASSEMBLY ABOVE

**DENOTES THAT PART IS INCLUDED WITH ASSEMBLY ABOVE

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D412-742 REV. D AND
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D412-742 REV. 3.

REF. FAA STC: SR01583SE
REF. CANADIAN STC: SH05-37
REF. EASA STC: EASA.IM.R.S.01126

REFERENCE ON

INSTRUCTIONS:

- 1) FOR D412-742-011/-013 SKIDTUBES @ CHANGE 006 AND SUBSEQUENT, UPDATE THE PARTS LIST TO MODIFY THE BOLT USED TO ATTACH THE GHW LUG AS FOLLOWS:

5.1 D412-742-011 (PMA/OEM) Float Skidtube Installation Parts List

32.15 D412-742-011 (PMA/OEM) Float Skidtube Installation Parts List

ITEM	Qty -011	Qty -041	Qty -015	PART NUMBER	DESCRIPTION
	X			D412-742-011	FLOAT SKIDTUBE INSTALLATION
	1	X		D412-742-041	FLOAT SKIDTUBE
	1		X	D412-742-015	ELECTRIC STEP KIT

IS:

63	4			AN4C47A	BOLT
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WAS:

63	4			AN4C46A	BOLT
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5.2 D412-742-013 (APICAL TRI-BAG) Float Skidtube Installation Parts List

32.16 D412-742-013 (APICAL TRI-BAG) Float Skidtube Installation Parts List

ITEM	Qty -013	Qty 043	PART NUMBER	DESCRIPTION
	X		D412-742-013	FLOAT SKIDTUBE INSTALLATION
	1	X	D412-742-043	FLOAT SKIDTUBE

IS:

63	4			AN4C47A	BOLT
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WAS:

63	4			AN4C46A	BOLT
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A	NEW ISSUE	AJS	08.12.19
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9441	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		BOLT CHANGE	NTS
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